














Date: Monday, 16/03/2009 2:00:43 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: CABIN FLOOR PROTECTOR
<b>Job Number</b>	: 46510		
<b>Estimate Number</b>	: 12661		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D35742
<b>This Issue</b>	: 16/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D3574 REV.A
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b>	: A
<b>Previous Run</b>	: 45253	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 24/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JUL 09.03.14</u>		
<b>Comment</b>	: Est Rev :A New Issue 07-01-22 EC		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	 ML-EXS125F6002902	GE PLASTICS LEXAN SHEET	
			
<b>Comment:</b> Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s) lexan sheet Batch:  ml 09 03 19 (4)			
2.0	WATER JET	FLOW WATER JET	
			
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary ml 09 03 19 (4)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE ml 09 03 19 (4)			
4.0	QC8	SECOND CHECK	
			
<b>Comment:</b> SECOND CHECK 09 03 19 (4)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. SAD 09-03-20 (4)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 16/03/2009 2:00:43 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 46510

Part Number: D35742

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 09.03.2009 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location:            *Handwritten:* 11P 46507 91355

*Handwritten:* 18 50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 09/03/25

Job Completion



*Handwritten:* MF 09-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	H6510
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: A		Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.00	✓		VEN	
7.37	+/-0.030	7.37	✓		M.T	
11.00	+/-0.030	11.00	✓		M.T	
15.25	+/-0.030	15.25	✓		M.T	
25.87	+/-0.030	25.87	✓		M.T	
39.75	+/-0.030	39.75	✓		M.T	
44.75	+/-0.030	44.75	✓		M.T	
53.51	+/-0.030	53.51	✓		M.T	
63.50	+/-0.030	63.50	✓		M.T	
65.25	+/-0.030	65.25	✓		M.T	
10.75	+/-0.030	10.75	✓		M.T	
14.75	+/-0.030	14.75	✓		M.T	
25.50	+/-0.030	25.50	✓		M.T	
25.75	+/-0.030	25.75	✓		M.T	
26.00	+/-0.030	26.00	✓		M.T	
32.87	+/-0.030	32.87	✓		M.T	
38.81	+/-0.030	38.81	✓		M.T	
45.00	+/-0.030	45.00	✓		M.T	
58.38	+/-0.030	58.38	✓		M.T	
61.25	+/-0.030	61.25	✓		M.T	
64.13	+/-0.030	64.13	✓		M.T	
64.63	+/-0.030	64.63	✓		M.T	
7.50	+/-0.030	7.50	✓		M.T	
9.50	+/-0.030	9.50	✓		M.T	
10.38	+/-0.030	10.38	✓		M.T	
10.88	+/-0.030	10.88	✓		M.T	
14.50	+/-0.030	14.50	✓		M.T	
16.56	+/-0.030	16.56	✓		M.T	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	46510
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-2
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

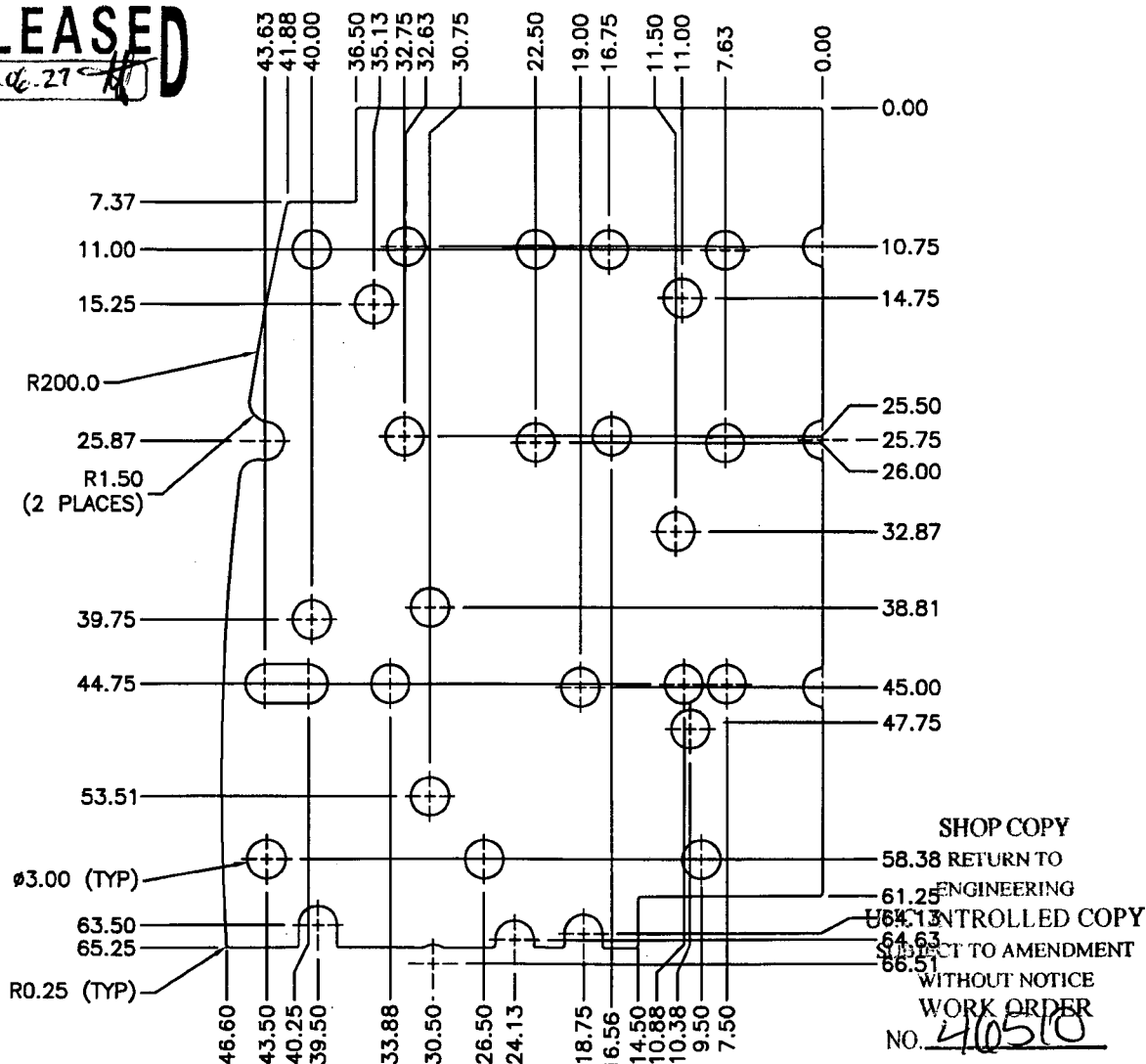
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.75	+/-0.030	18.75	✓		M.T	
24.13	+/-0.030	24.13	✓		M.T	
26.50	+/-0.030	26.50	✓		M.T	
30.50	+/-0.030	30.50	✓		M.T	
33.88	+/-0.030	33.88	✓		M.T	
39.50	+/-0.030	39.50	✓		M.T	
40.25	+/-0.030	40.25	✓		M.T	
43.50	+/-0.030	43.50	✓		M.T	
46.60	+/-0.030	46.60	✓		M.T	
7.63	+/-0.030	7.63	✓		M.T	
11.00	+/-0.030	11.00	✓		M.T	
11.50	+/-0.030	11.50	✓		M.T	
16.75	+/-0.030	16.75	✓		M.T	
19.00	+/-0.030	19.00	✓		M.T	
22.50	+/-0.030	22.50	✓		M.T	
30.75	+/-0.030	30.75	✓		M.T	
32.63	+/-0.030	32.63	✓		M.T	
32.75	+/-0.030	32.75	✓		M.T	
35.13	+/-0.030	35.13	✓		M.T	
36.50	+/-0.030	36.50	✓		M.T	
40.00	+/-0.030	40.00	✓		M.T	
41.88	+/-0.030	41.88	✓		M.T	
43.63	+/-0.030	43.63	✓		M.T	

<b>Measured by:</b>	M.M	<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09.03.19	<b>Date:</b>	06.05.19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

**RELEASED**  
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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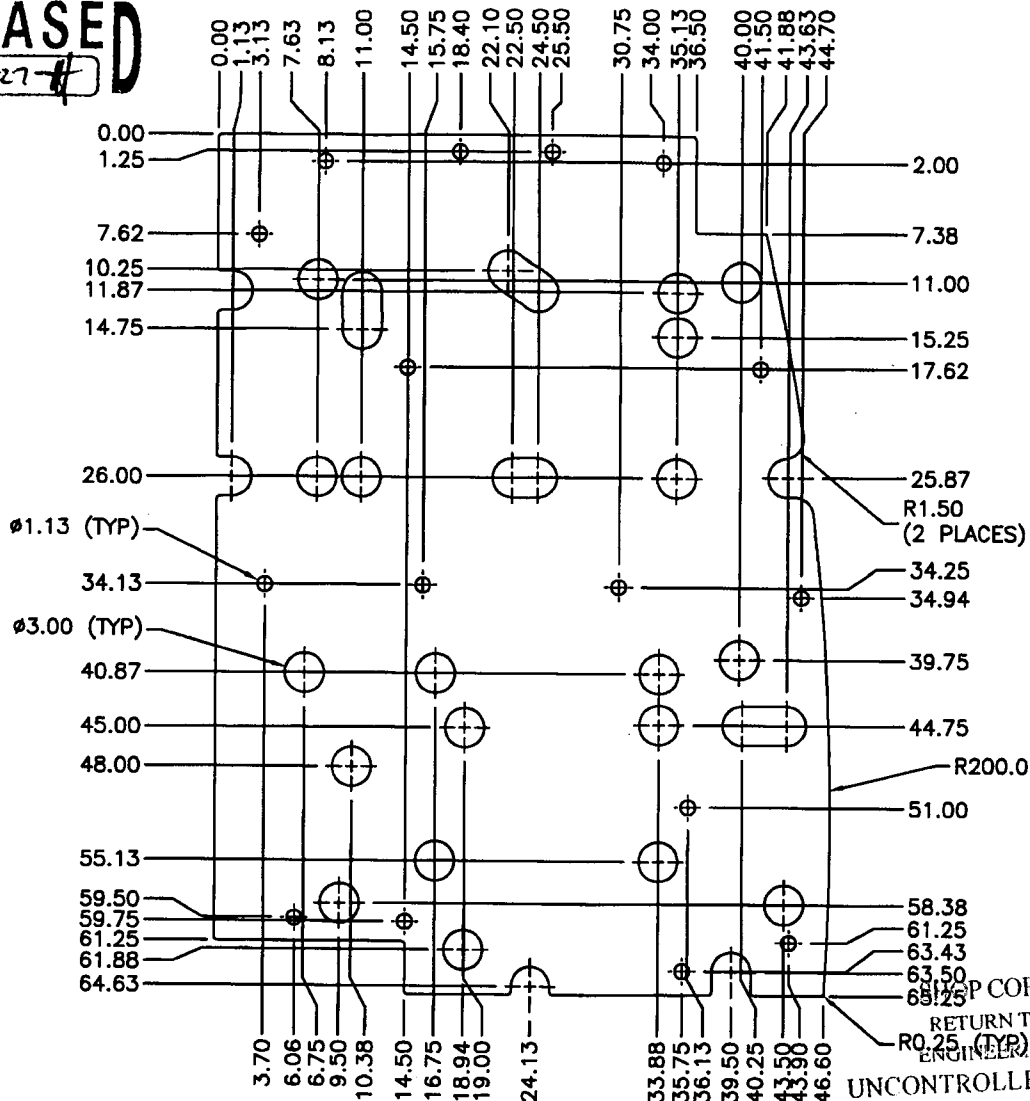
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**DART**

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 3 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

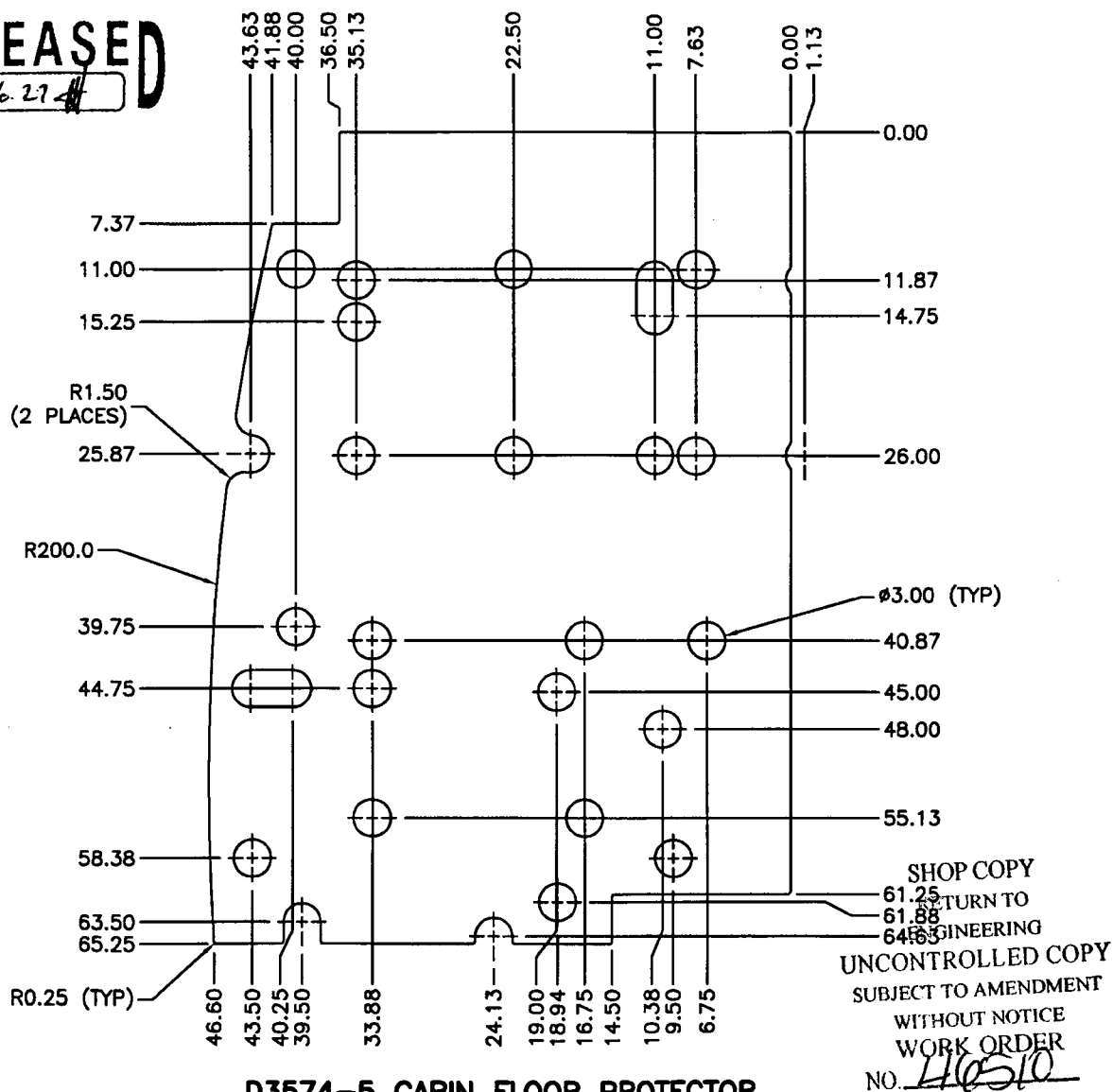
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED  
07.06.27



### D3574-5 CABIN FLOOR PROTECTOR

#### NOTES:

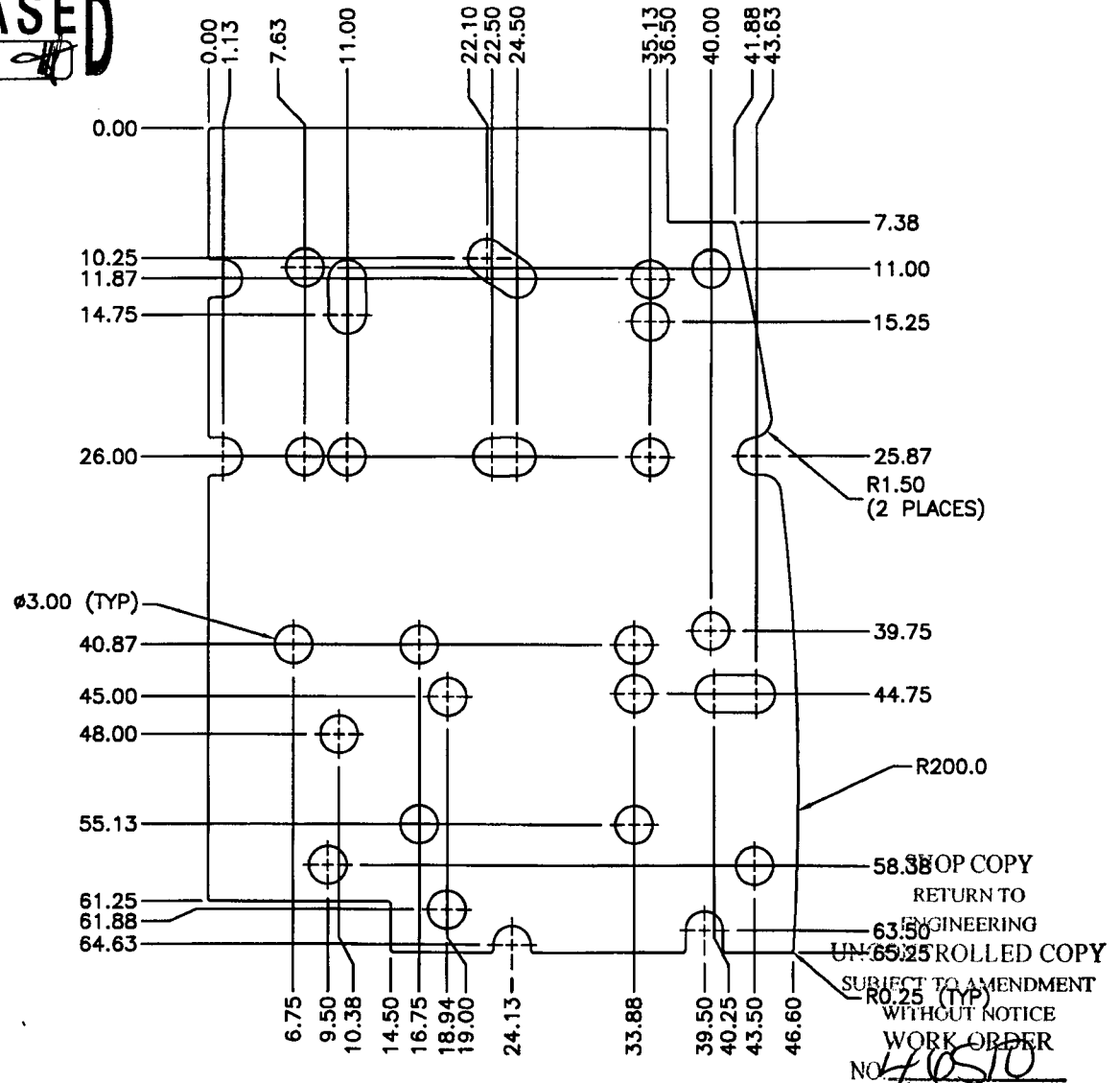
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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**DART**

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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